

Work Order ID 84063

May-02-12 11:48:35 AM

84063

Page 1

Item ID: D2432

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 206 (24") Bearpaw

Start Date: 5/02/12 Start Qty: 12.00

12

Cust Item ID:


Required Date: 5/11/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

UHMW 1" Blk

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

12-5-6
12-07-03
12-07-07

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Page 2

Item ID: D2432

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206 (24") Bearpaw

Start Date: 5/02/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/11/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: _____

0.00

151

Packaging

Memo

PP086 336

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

OK 12/07/10 4

9 0

PCW/2/6 (9)

OK 12/7/10
MK
12-07-06

Picklist Print

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Page 1

Work Order ID: 84063
Parent Item: D2432
Parent Item Name: 206 (24") Bearpaw

Start Date: 5/02/12
Start Qty: 12.00

Required Date: 5/11/12
Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			120	sf	231.2100	3.7	44.4			

Location

Loc Qty

Loc Code

MAT018

30.1

120972

3

121346

27.1

MAT019

1.5

118814

1.5

ST052

199.6099947

121277

12.8

121278

186.809995

121278

RD-5-6

(9)



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MPK</i>	APPROVED <i>SA</i>	DRAWING NO. D2432	REV. F SHEET 1 OF 2
DATE 98.05.12	TITLE BEARPAW	SCALE 1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

RELEASED
98.06.17 KE

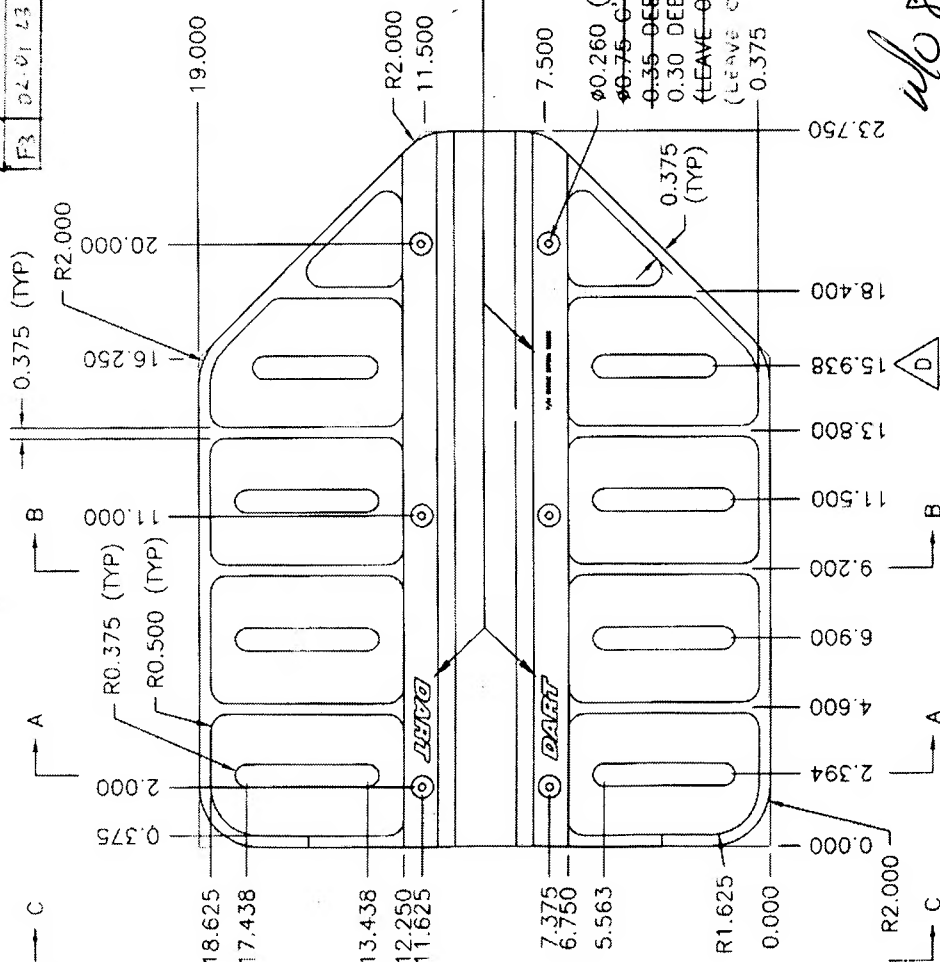
ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

EFFECTIVE

DEOS

9143

F1	19.03.97	ADD DEC 9143
F2	01.03.28	REV. 3 WAS 0070
F3	02.01.23	CLARIFY BORE PMS



W/O 8463

BEND AFTER MACHINING
(D2432B ONLY)

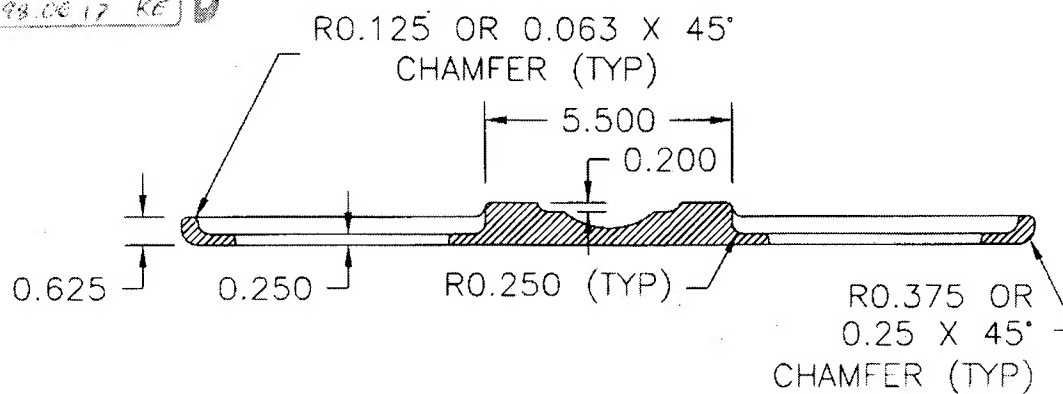
D2432E: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

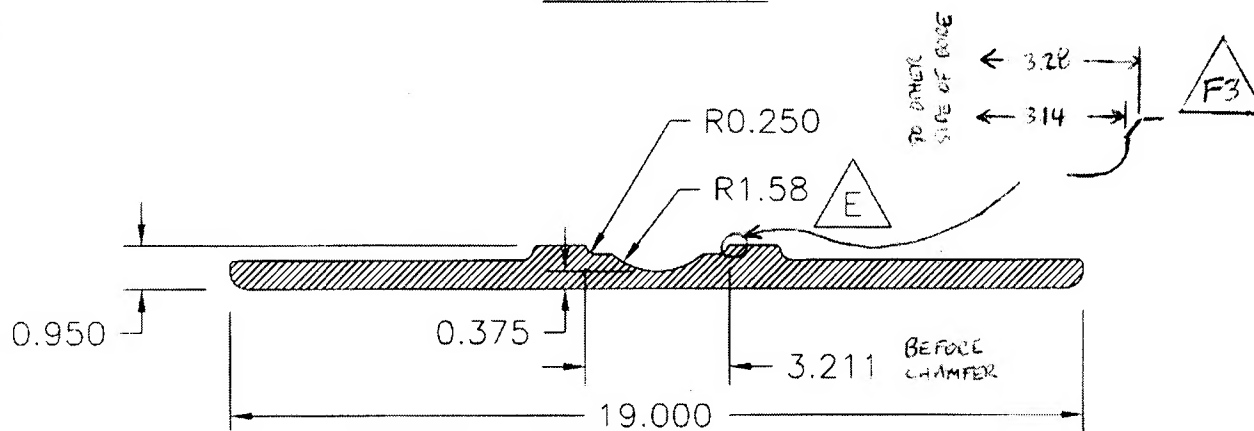


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ME	APPROVED CS	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

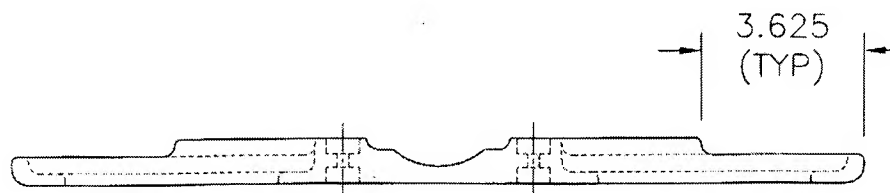
RELEASED
98 DEC 17 KE



SECTION A-A



SECTION B-B



SECTION C-C

DART AEROSPACE LTD		Work Order: 84063	
Description: Bearpaw		Part Number: D2432	
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.053	✓		ven	RT-4
B	5.500	+/-0.030	5.500	✓		"	
C	0.200	+/-0.030	.212	✓		depth gauge	RT-6
D	0.25 x 45°	+/-0.030	.250	✓		ven	RT-4
E	R0.250	+/-0.030	.250	✓		red gauge	
F	0.250	+/-0.010	.254	✓		ven	
G	0.625	+/-0.030	.627	✓		"	
H	0.375	+/-0.010	.374	✓		"	
I	0.950	+0.030/0.010	.966	✓		"	
J	19.000	+/-0.030	19.000	✓		Tape	RT-10
K	3.14	+/-0.030	3.125	✓		ven	
L	3.28	+/-0.030	3.298	✓		"	
M	Ø0.260	+0.005/-0.000	.260	✓		"	
N	Ø0.93	+/-0.030	.926	✓		"	
O	0.30	+0.030/-0.000	.305	✓		"	
P	23.750	+/-0.030	23.750	✓		Tape	RT-10
Q	7.375	+/-0.030	7.375	✓		"	
R	4.250	+/-0.010	4.252	✓		ven	RT-4
S	2.000	+/-0.030	1.996	✓		"	
T	9.000	+/-0.010	9.000	✓		Tape	RT-10
U	9.000	+/-0.010	9.000	✓		"	
V	0.375	+/-0.010	.378	✓		ven	RT-4

Measured by: RT	Audited by: gmf	Prototype Approval:	N/A
Date: 12-07-03	Date: 12/07/04	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	RT